

Date: Thursday, 6/15/2006 1:41:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LOCK PLATE
 Job Number : 27556A
 Estimate Number : 10332
 P.O. Number : N/A Part Number : D2534
 This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D2534 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : D
 Previous Run : 26406A Material : N/A
 Written By : SENA COMMENT Below Due Date : 6/30/2006 Qty: 51 Um: 40 Each
 Checked & Approved By : HA 06.06.15
 Comment : Est Rev:A New Issue 05-11-07 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Order (2) D2534 per (1) D2530

Issue P/O:

Email or ship DXF file to vendor

Laser cut D2534 flat pattern per Dwg D2534

Material release note required

MATERIAL: 304 SS .125" THK.
 (M304S116A)

(.045 SF)

Batch: M6789

M6789

2.0 ~~D2534F~~ Lock Plate



Comment: Qty: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Lock Plate

Deburr

M.F. 06/06/30

SAD 06:06:22

51

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

N/A

4.0 QCB 2 DIMENSIONAL CHECK



Comment: Inspect dimensions per template D2534-T1

SAD

06:06:22

51

5.0 SMALL FAB T QCB SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

M.F. 06/06/30

51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DS* Date: 16/08/03

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:41:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK PLATE

Job Number: 27556A

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

M 06/07/26 (57)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/03 (51)

Job Completion



C 206/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

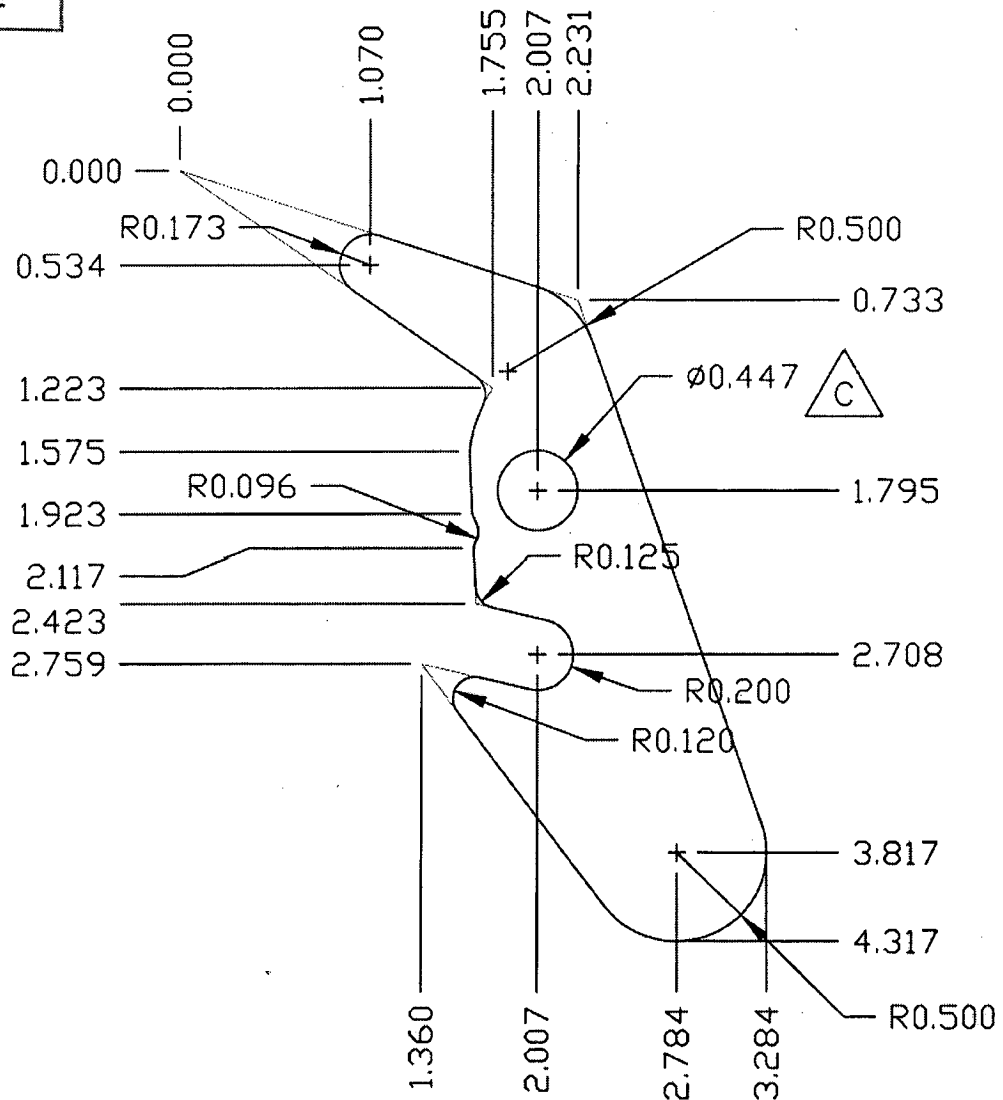
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. D
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2534	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	LOCK PLATE		1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK) (REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **27556A**

Date: Wednesday, 6/21/2006 9:15:56 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LOCK PLATE
Job Number :	27556A		
Estimate Number :	10332		
P.O. Number :	N/A	Part Number :	D2534
This Issue :	6/21/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2534 REV D
First Issue :	6/15/2006	Project Number :	N/A
Previous Run :	26406A	Drawing Revision :	D
	Type :	Material :	N/A
	SMALL /MED FAB	Due Date :	6/30/2006
Written By :	<i>SEE COMMENT BELOW</i>		Qty: 40 Um: Each
Checked & Approved By :			
Comment :	Est Rev:A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0450 sf(s)/Unit Total : 1.8000 sf(s)
 304/316 .063 Sheet

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect dimensions per template D2534-T1

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

Date: Wednesday, 6/21/2006 9:15:56 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK PLATE

Job Number: 27556A

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion

